

Date: Tuesday, 07/04/2009 3:21:15 PM
 User: Melanie Fauteux

Process Sheet

| | | | |
|-----------------------|--|------------------|-------------------------------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : AFT ADJUSTABLE BLADE SUPPORT ASSY |
| Job Number | : 47051 | | |
| Estimate Number | : 13436 | | |
| P.O. Number | : | Part Number | : PB674300113 GN |
| This Issue | : 07/04/2009 S.O. No. : | Drawing Number | : B6743001 P.8 |
| Prsht Rev. | : NC | Project Number | : N/A |
| First Issue | : 07/04/2009 Type : LARGE FAB ASSY | Drawing Revision | : B1 |
| Previous Run | : 45042 | Material | : |
| Written By | : | Due Date | : 14/04/2009 Qty: 1 Um: Each |
| Checked & Approved By | : <u>MF 09-04-08</u> | | |
| Comment | : Est Rev:A 08-06-26 new issue DD verified by:ec | | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|--------------|------------|
| 1.0 | PB6743001255 | Inner Tube |
|-----|--------------|------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Inner Tube

batch: B44781 = 1X

Sp 09.04.20

| | | |
|-----|--------------|--------------------|
| 2.0 | PB6743001249 | Inner Tube Bushing |
|-----|--------------|--------------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Inner Tube Bushing

batch: B44784 = 1X

Sp 09.04.20

| | | |
|-----|--------------|--------|
| 3.0 | PB6743001253 | Gusset |
|-----|--------------|--------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Gusset

batch: B44783 = 1X

Sp 09.04.20

| | | |
|-----|--------------|--------|
| 4.0 | PB6743001254 | Gusset |
|-----|--------------|--------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Gusset

batch: B44782 = 1X

Sp 09.04.20

| | | |
|-----|-------------|---------------|
| 5.0 | PB674300167 | PB67-43001-67 |
|-----|-------------|---------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

PB67-43001-67

batch: B45022 = 1X

Sp 09.04.20

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Tuesday, 07/04/2009 3:21:15 PM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT ADJUSTABLE BLADE SUPPORT ASSY

Job Number: 47051

Part Number: PB674300113

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

- 1- make a 0.090" chamfer in the 1.00" hole before welding
- 2- assemble parts and weld as per dwg

SP 09.04.20 (1X)

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

SP 09/04/20 (X)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SP 09/04/20 (X)

9.0

MS124780

HELICAL INSERT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
HELICAL INSERT M111064

SP 09.04.21

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

- 1- grind weld flush in area of PB67-43001-249 only
- 2- install helicol insert as per dwg

SP 09.04.21

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SP 09/04/21

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

a/a

13.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

1- MASK TUBE FROM BASE TO GUSSET

2- Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

SP 09-04-21 (1)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Tuesday, 07/04/2009 3:21:15 PM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT ADJUSTABLE BLADE SUPPORT ASSY

Job Number: 47051

Part Number: PB674300113

Job Number:



Seq. #:

Machine Or Operation:

Description :

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

11:00
350°
11:30

M 18/44

BL

09-04-21

①

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-04-21

(X)

15.0

PB674300169

90 Degree Cover Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

90 Degree Cover Plate

batch: B45762

EP09/05/06

16.0

PB674300183

PB67-43001-83



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

PB67-43001-83

batch: B47042

EP09/05/06

17.0

MS27039110

Screw



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Screw

batch: M111425

EP09/05/06

18.0

NAS1149F0316P

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

WASHER

batch: M111117

EP09/05/06

19.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- match drill cover to existing holes in support

2- assemble as per dwg

EP09/05/06 ①

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Tuesday, 07/04/2009 3:21:15 PM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT ADJUSTABLE BLADE SUPPORT ASSY

Job Number: 47051

Part Number: PB674300113

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

502/05/06 (R)

21.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WA

09-05-06 1

22.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/06 JG

Job Completion



MF
09-05-06

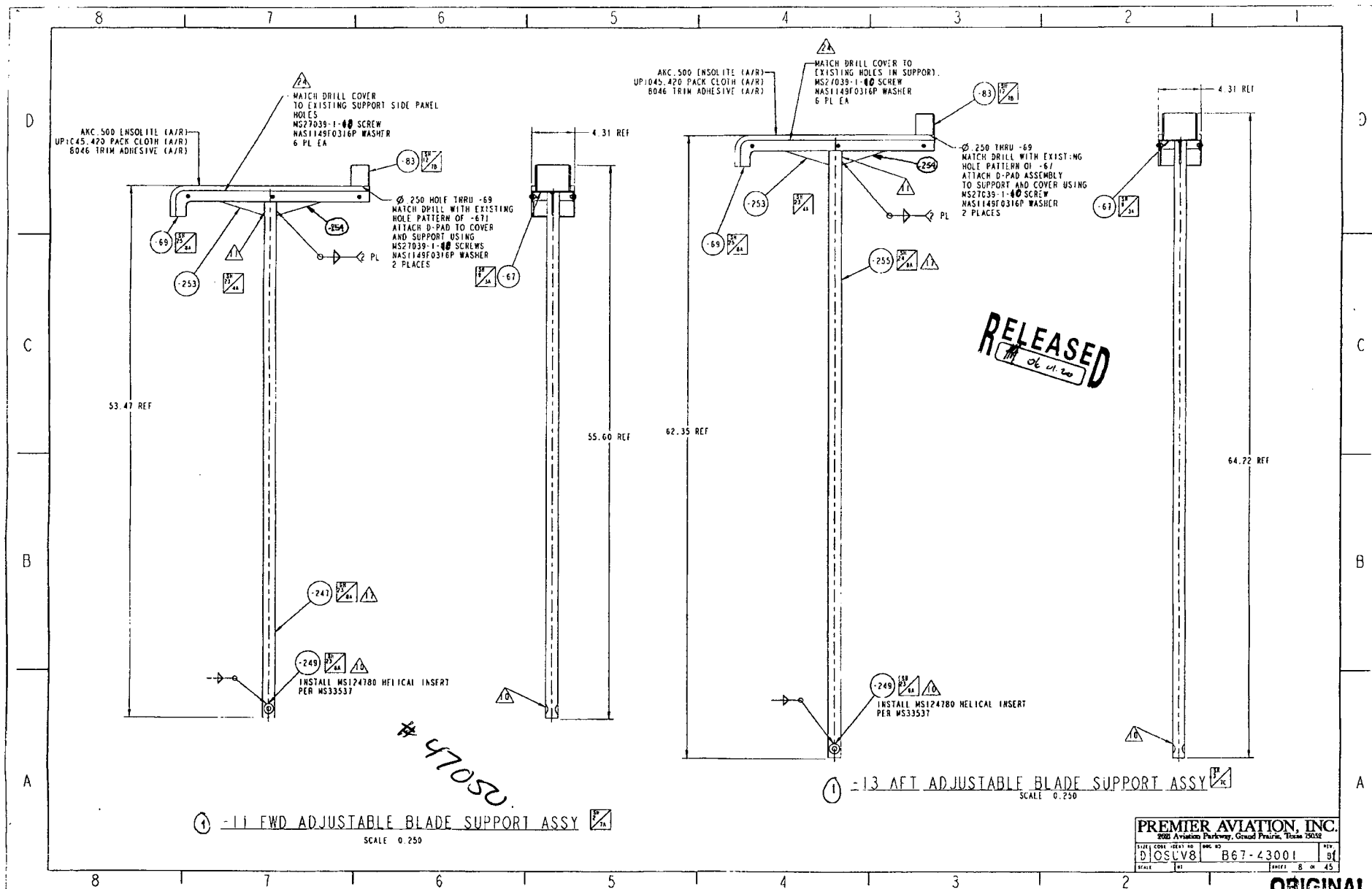
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



ORIGINAL